

Work Order ID 133166

Tuesday, May 26, 2015 12:49:25 PM

646.3210
B 133166
REV. N/C

133166

Page 1

Item ID: 646.3210

Revision ID:

Item Name: Support

Start Date: 6/01/15

Start Qty: 4.00

4

Required Date: 6/01/15

Req'd Qty: 4.00

4

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: MAY 27 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.3200

n/c

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 10.35"

0.00

0.00

DAS

37

9-30

15.05.31

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB146

DWG REV: 11/5

FOLIO REV: 40

0.01

0.07

DAS

37

9-30

15.06.05

2- deburr and break all sharp edges

PTO

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

Work Order: <u>133166</u> Part No. <u>646.3210</u> NCR No.		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Description Work Order Deviation				Disposition																																																																			
.100 I.OOS IS MEASURING. .086 AT IS SMALLEST. DID NOT RUN & FINISH PASS. P.C. program. had handwritten note that had no approval signature				SCRAP CHANGE PROGRAM WITH A .005 DESTROY. FINISH PASS. Re-run in 131357 program has been updated: <u>[Signature]</u> <u>15.06.09</u>				Completed By <u>[Signature]</u> Lead hand / Supervisor Approval Verification DAS <u>08</u> <u>9-89</u> QC / QA Coordinator Approval DAS <u>9</u> <u>9-89</u> <u>15.06.09.</u>																																																															
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Work Order ID 133166

Tuesday, May 26, 2015 12:49:25 PM

133166

Page 2

Item ID: 646.3210

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 6/01/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/01/15

Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

4

1

DAS
37
9-89

15.05.06

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

15/06/10

4

0

DAS
08
9-89

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

4.80

Outsource process - Anodize

Issue P/O to ATG : 28900

1- Black Anodize as per Dwg 646.3200

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Comformity is required

CZ JUN 22 2015

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

Work Order ID 133166

Tuesday, May 26, 2015 12:49:25 PM

133166

Page 3

Item ID: 646.3210 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 6/01/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/01/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>CCK020</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								

4x 8/15-07-28

④ **DAS 38 9-89**
AUG 05 2015

④ **DAS 27 9-89**
AUG 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																																																															

Picklist Print

Tuesday, May 26, 2015 12:49:24 PM

Page 1

Work Order ID: 133166

133166

Parent Item: 646.3210

646.3210

Parent Item Name: Support

Start Date: 6/01/15

Required Date: 6/01/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-11-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B6.000X1.000		Purchased		No			f	135.0000		3.629474		DAS 37 9-99	
M7075T6B6 000X1 000												15.05.31	
7075-T6 BAR 6.000" X 1.000"													

Location	Loc Qty	Loc Code
MAT005	135	
M129891	9	
M130014	90	
M131357	36	

3.629474

7.866 ft. 15.06.05

DQA: _____ Date: _____



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Work Order update only ☐

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OTHER :					

FIRST ARTICLE INSPECTION CHECKLIST

DAS

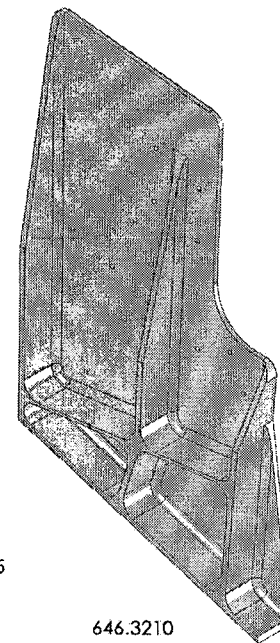
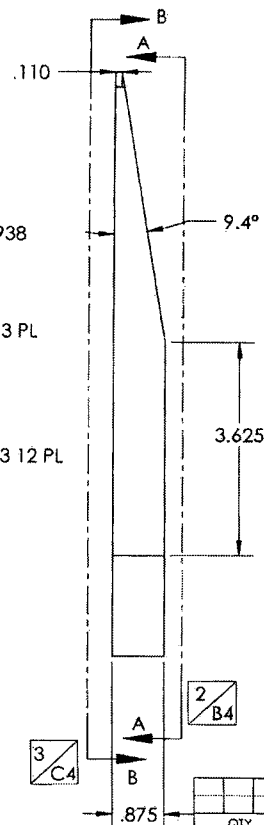
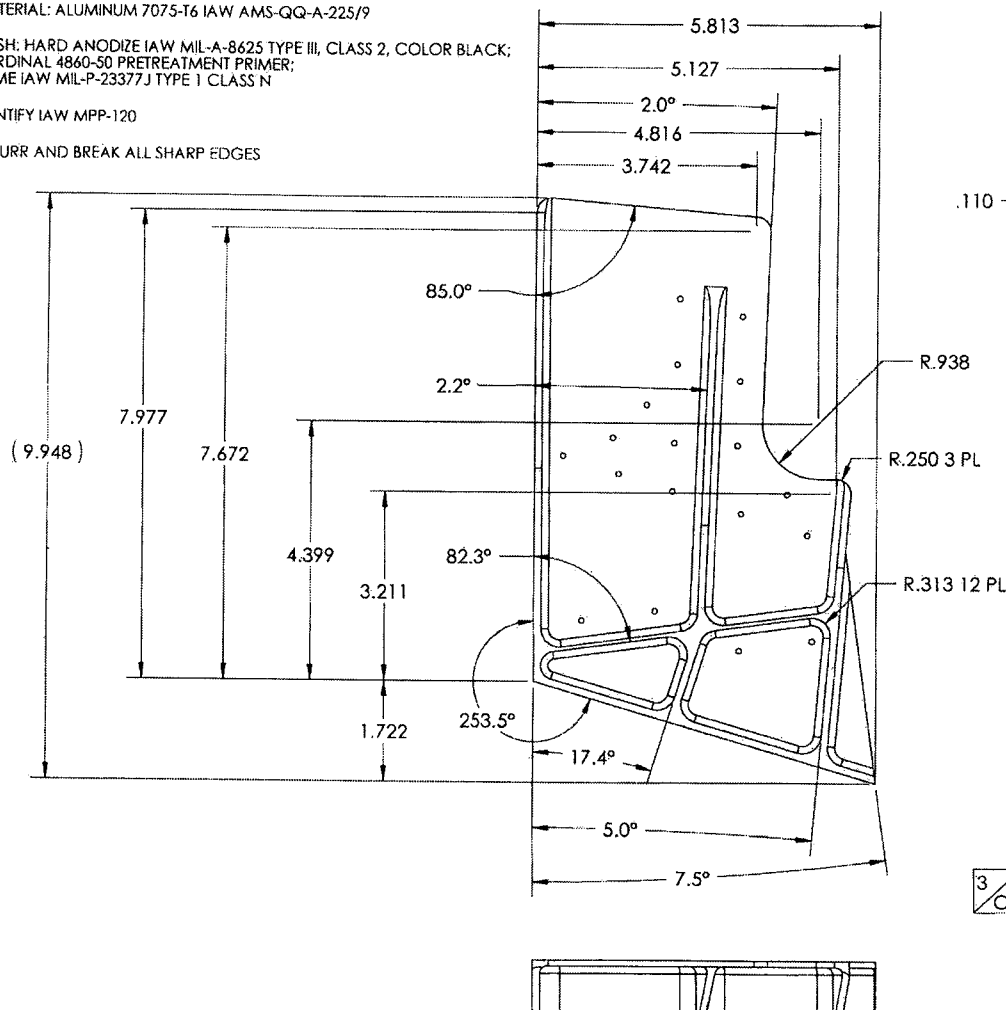
~~37~~
9-29

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NOTES:

- ① MATERIAL: ALUMINUM 7075-T6 IAW AMS-QQ-A-225/9
- ② FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER;
PRIME IAW MIL-P-23377J TYPE 1 CLASS N
3. IDENTIFY IAW MPP-120
4. DEBURR AND BREAK ALL SHARP EDGES

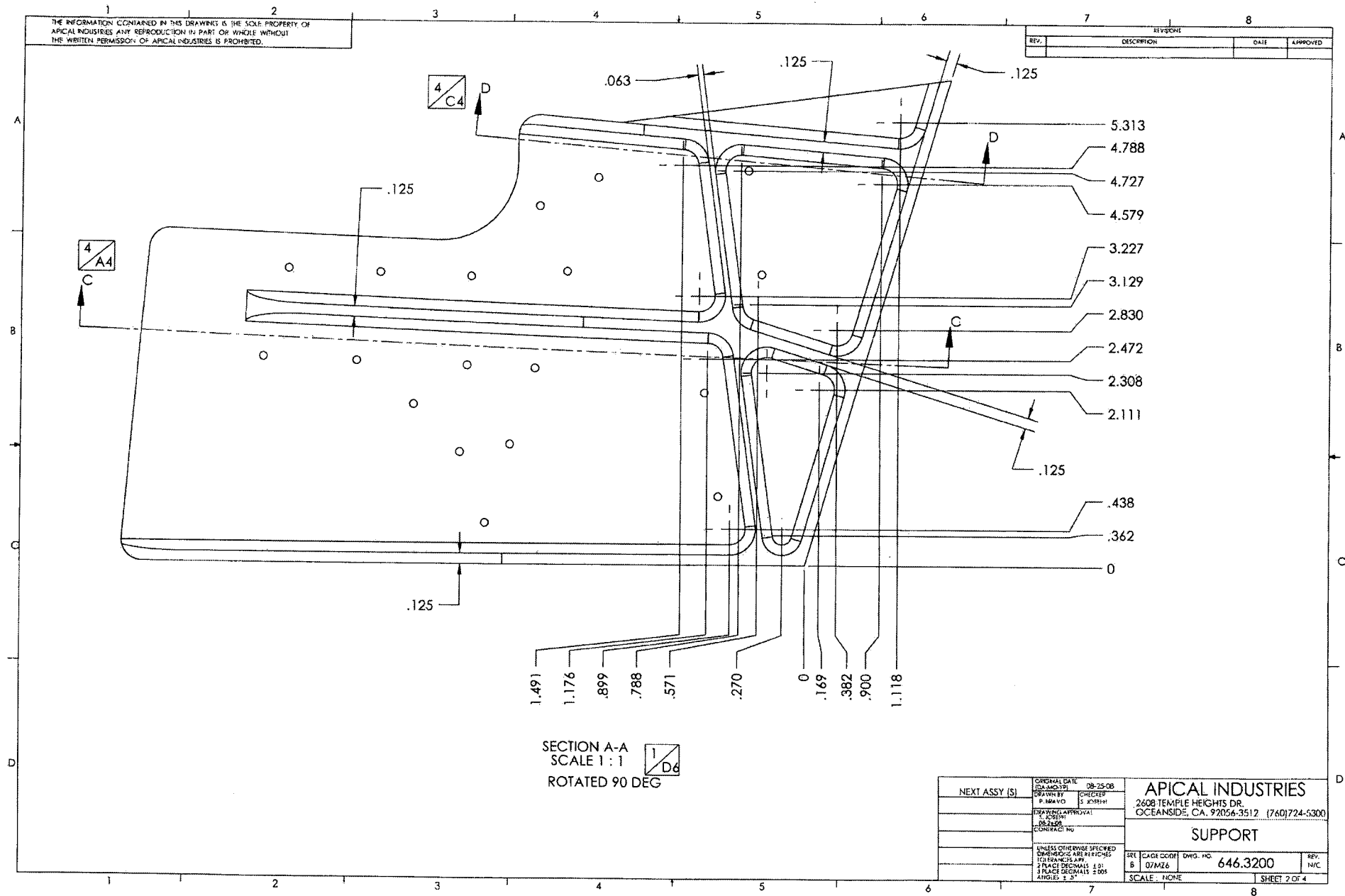


SHOP COPY
RETURN TO
1. C. H. H. H. H.
USE OF ANY OTHER COPY
SUBJECT TO THE FOLLOWING
WITHOUT NOTICE
WORK ORDER
NO. 133-166-

MLS
15-05-27

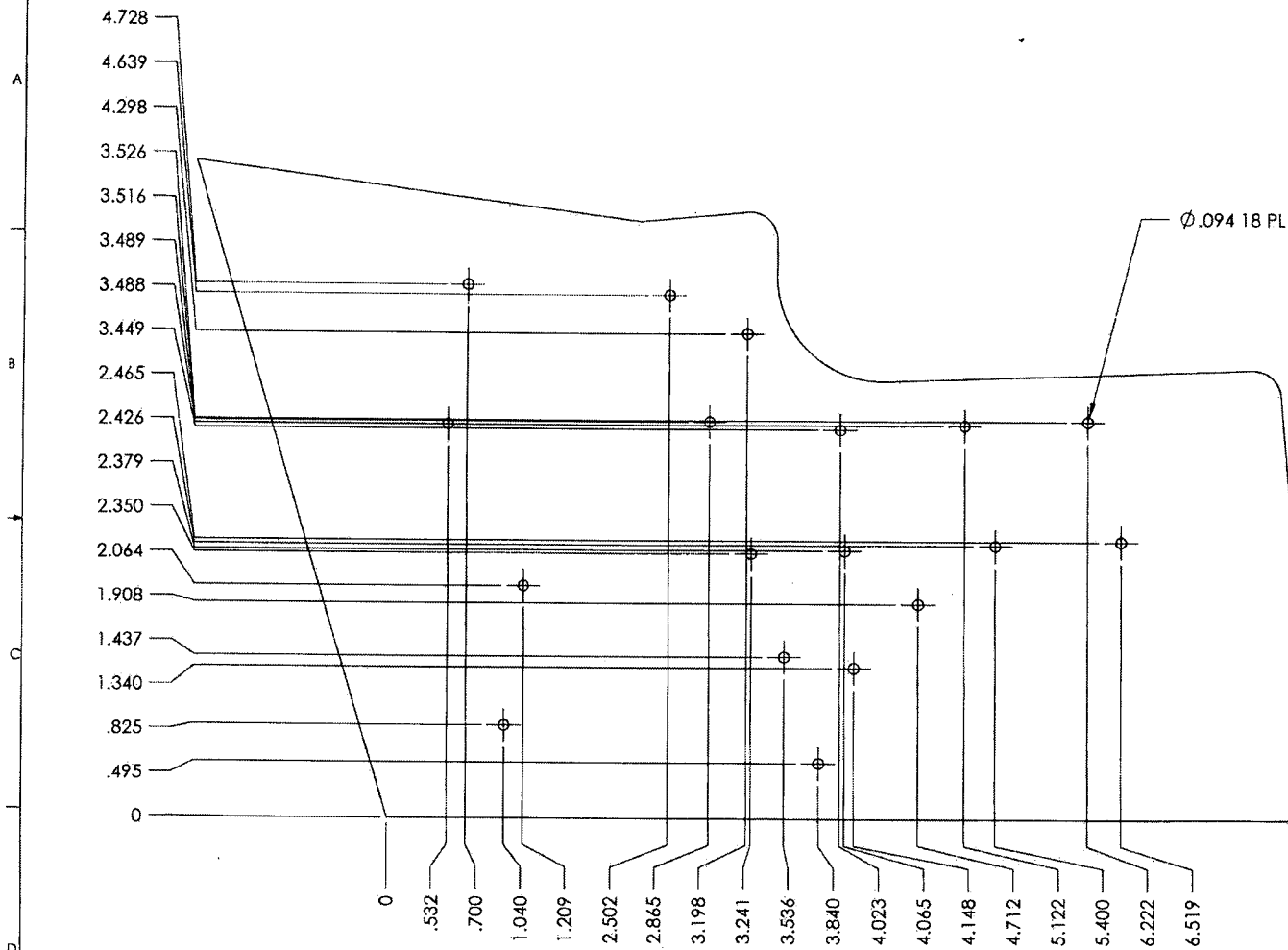
[illegible]

REVISION			
REV.	DESCRIPTION	DATE	APPROVED



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REVISION			
REV	DESCRIPTION	DATE	APPROVED

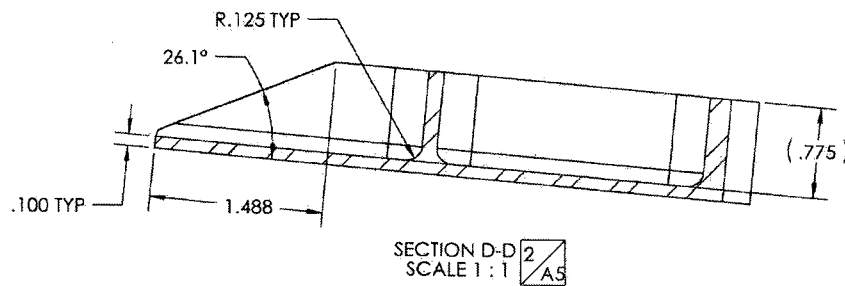
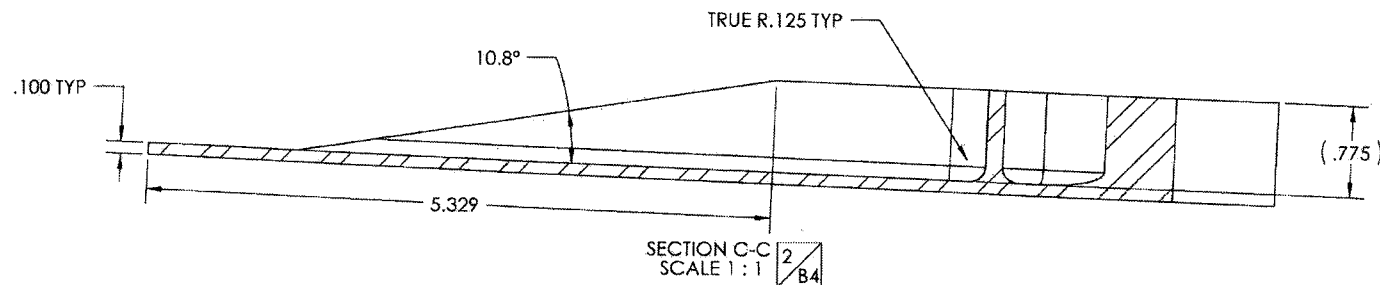


SECTION B-B
SCALE 1:1
ROTATED -90 DEG

NEXT ASSY (S)		ORIGINAL DATE 06-25-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. BRAYO		CHECKED S. JOSEPH		
DRAWING APPROVAL S. JOSEPH		DATE 06-25-08		
CONTRACT NO.				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 3 PLACE DECIMALS ±.01 ANGLES ±.2°			REV B	DATE 07/01/08
SCALE: NONE			DWG. NO. 646.3200	REV N/C
			SHEET 3 OF 4	

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



NEXT ASSY (S)	ORIGINAL DATE	CR-23-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY	CHECKER		
	9. BAWO	1. J. J. J.	SUPPORT	
	DRAWING APPROVAL			
	CONTRACT NO.		SCALE: NONE	
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	SHEET	CAGE CODE	DWG. NO.
		B	07M26	646.3200
				REV N/C
				SHEET 4 OF 4



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO28906

Purchase Order Date 6/22/2015

PO Print Date 7/28/2015

Page Number 3 of 4

Order From : VC-ATG001
A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613-446-4544	Customer POID	
Vendor Fax	613-446-4556	Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
		FOB	EXCA - (Free Carrier)
Ship Method	VENDOR'S TRUCK		
Ship Acct			

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
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4	132311	D4822-2 UPPER RIGHT DEFLECTOR REV. C	7/28/2015 Yes	1.00	\$30.00
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7/28/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2
PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

Line Total: \$30.00

5	133166	646.3210 SUPPORT REV.N/C	7/28/2015 Yes	4.00 ✓	\$57.40
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7/29/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2
PRIME: AS PER IAW MIL-P-23377J TYPE I, CLASS N

8015-07-28

7/28/2015



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 63845

Date: 28-Jul-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	Line:
7 ea	Part: D4822-1 STRIP PRIMER & ANODIZE HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150579		PO: PO28906
6 ea	Part: D4822-2 UPPER DEFLECTOR, RH STRIP PAINT & ANODIZE HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150580		PO: PO28906
1 ea	Part: D4822-2 UPPER DEFLECTOR, RH HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150581		PO: PO28906
4 ea	Part: 646.3210 SUPPORT HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2	Rev: N/C	

SP15-07-28



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 63845

Date: 28-Jul-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

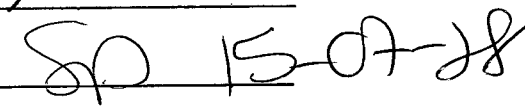
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150582 PO: PO28906 Line:		
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: <u>28/7/15</u> CERTIFIED SIGNATURE: <u></u> RECEIVER SIGNATURE: <u></u>			